

Date: Thursday, 20/11/2008 3:35:19 PM  
User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY			
Job Number	: 43622						
Estimate Number	: 10712						
P.O. Number	:			Part Number	: D32133		
This Issue	: 20/11/2008	S.O. No. :			Drawing Number	: D3213 REV A	
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type :	SMALL /MED FAB		Drawing Revision	: A	
Previous Run	: 42105			Material	:		
Written By	:			Due Date	: 28/12/2008		
Checked & Approved By	<u>JUL 08.11.21</u>			Qty:	6 Um: Each		
Comment	: Est Rev:A New Issue 05-11-17 JLM			Est Rev:B	Now on Waterjet 07-02-13 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		(10)
	Comment: Qty.: 0.4950 sf(s)/Unit Total : 2.9698 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3213-3 Batch: <u>108415</u>	<u>HB 8-12-10</u>
2.0	WATER JET	A FLOW WATER JET
		(10)
	Comment: FLOW WATER JET	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		(10)
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		(10)
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		(10)
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr	<u>HB 8-12-10</u>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		(10)
	Comment: HAND FINISHING RESOURCE #1	
	Chemical Conversion Coat as per QSI 005 4.1	<u>Fd 08/12/11</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:19 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43622

Part Number: D32133

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST180

SS 08/12/12 JC

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/15 JC

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43622
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213      Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-12-16	Date:	08/18/16	Date:	N/A

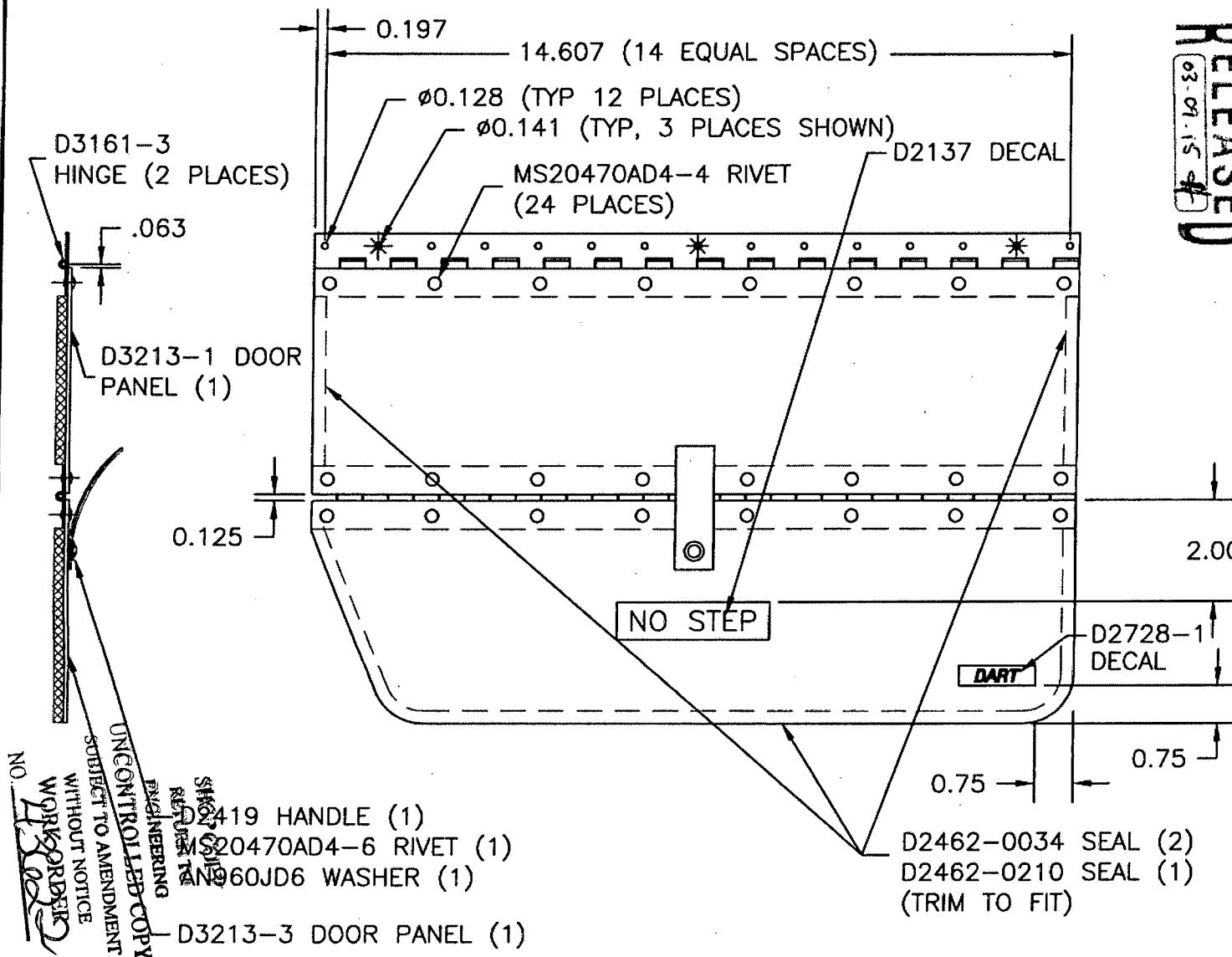
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	

**RELEASED**  
03-09-03

**DART**

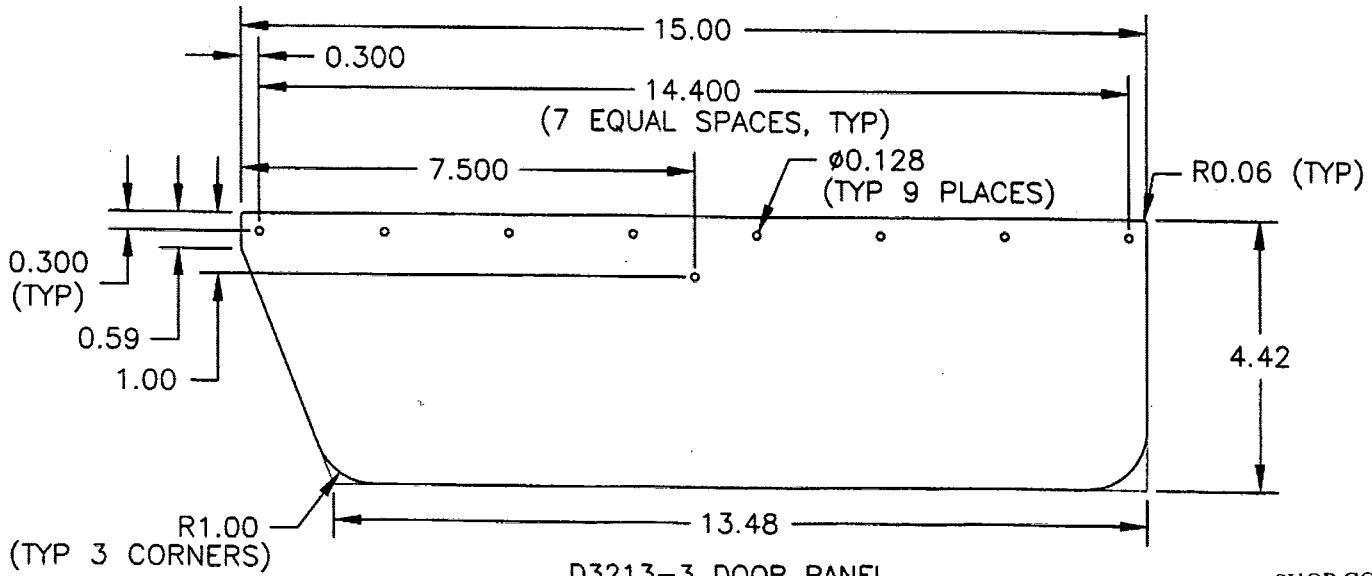
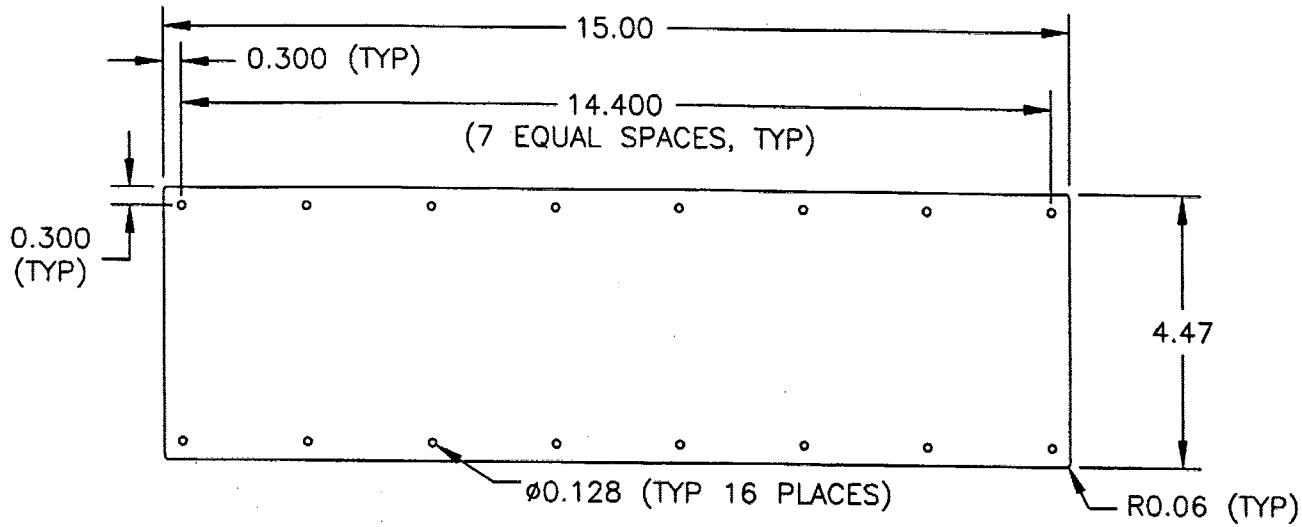


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.09.03	D3213	1 OF 2
A	03.09.03	SCALE 1:3
	NO. 2419	NEW ISSUE



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.03  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 43620

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